

Date: Monday, 22/12/2008 12:58:20 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 44227B		
Estimate Number	: 10207		
P.O. Number	:	Part Number	: D2989043
This Issue	: 22/12/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2989 REVC
First Issue	: / /	Project Number	:
Previous Run	: 42630B	Drawing Revision	: C
	Type	Material	:
	: LARGE FAB ASSY	Due Date	: 29/12/2008
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
-----------------	-------------	-------

2 D3182-1	Hinge	B 42293
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SY 08/12/23

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
-----------------	-------------	-------

2 D3442-3	Shim	B 42718
-----------	------	---------

SY 08/12/23

3.0	M304EX07516F	Expanded Metal Flat SS
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Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number	Description	Batch
-----------------	-------------	-------

8sf M304EX0.75-16F Expanded Metal		M109384
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SAD 08-12-23 (1)

4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.

Batch: M 110011

SAD 08-12-23 (1)

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Seq. #:

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Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

08/12/29
P 08.12.29
1x

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/01/05

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/01/05

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes in D2989-17 and D2989-2 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

11:40

OVEN TEMPERATURE:

400°

FINISH TIME:

12:10

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

12:45

OVEN TEMPERATURE:

400°

FINISH TIME:

1:15

09/01/05
C

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Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

02/01/06

10.0

QC21

FINAL INSPECTION/W/O RELEASE

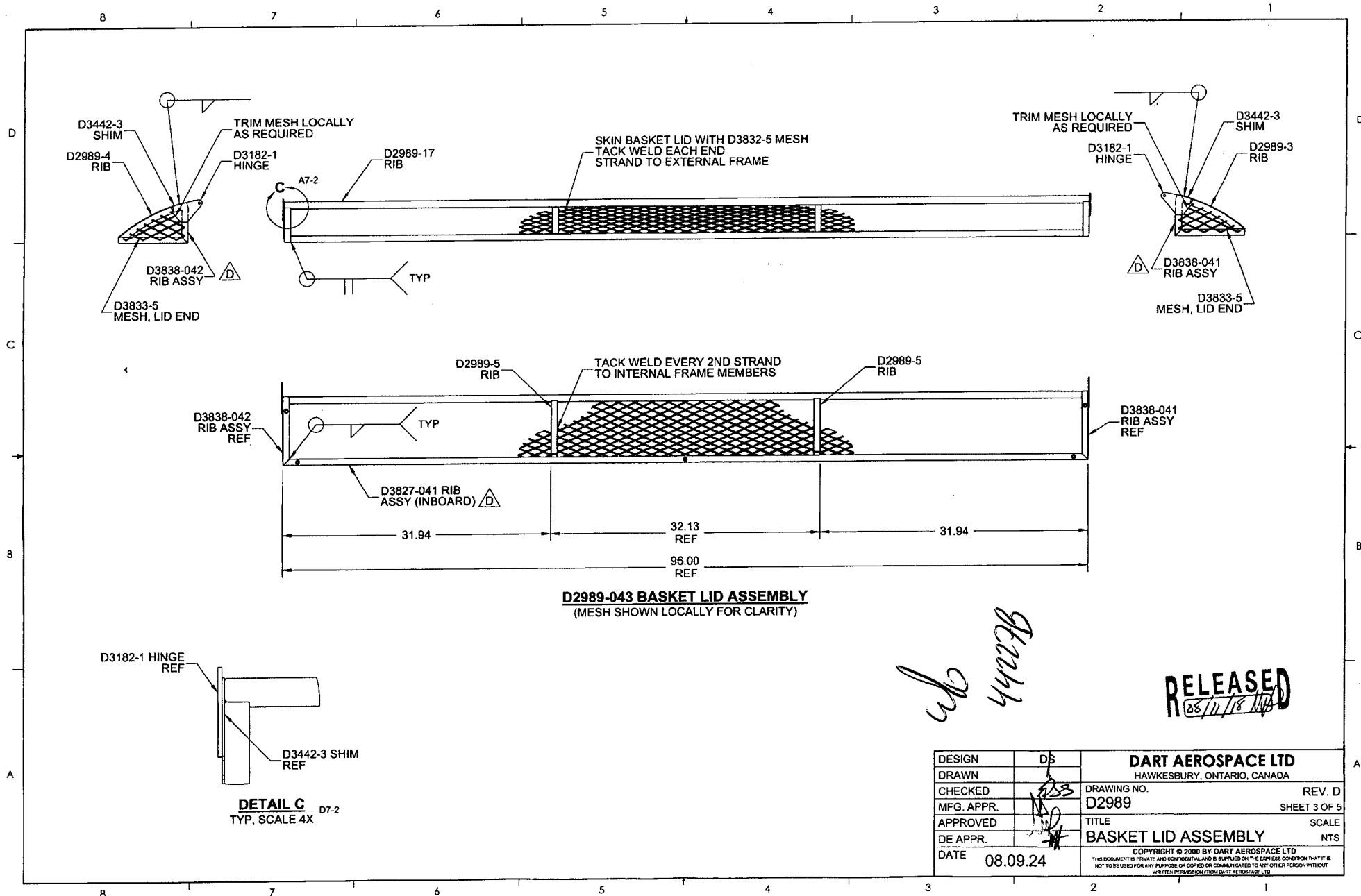


Comment: FINAL INSPECTION/W/O RELEASE

09/01/07
mf 09-01-07

Job Completion





Handwritten signature/initials

RELEASED
28/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

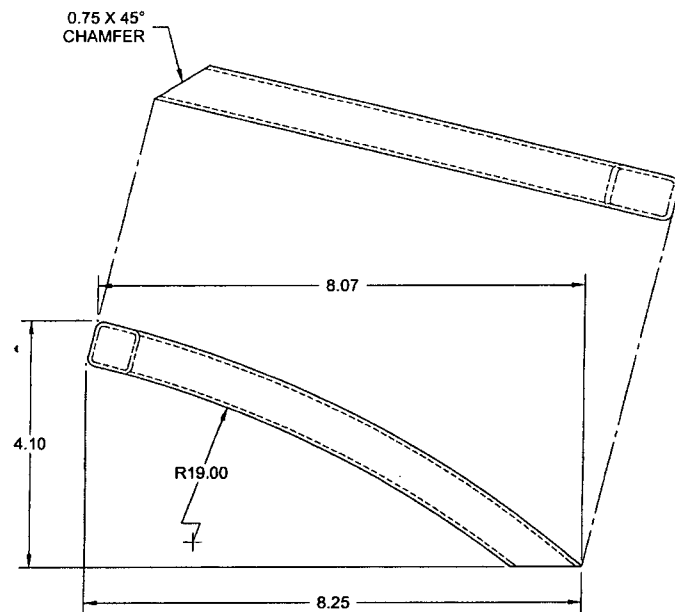
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

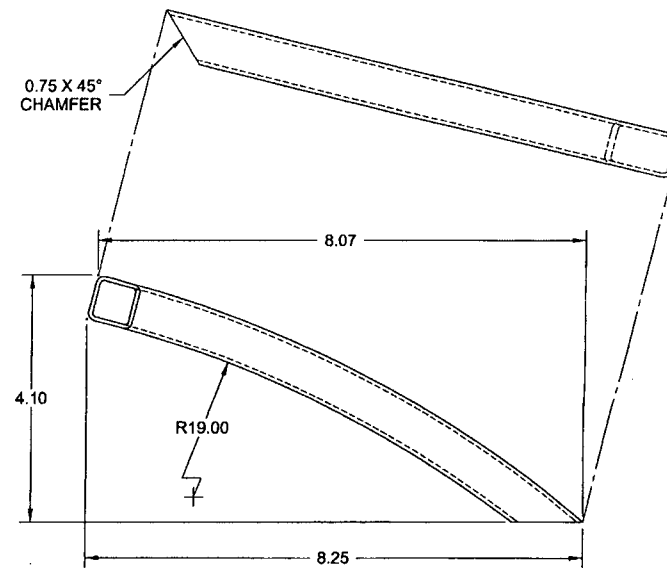
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

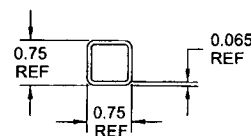


D2989-3 RIB



D2989-4 RIB

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

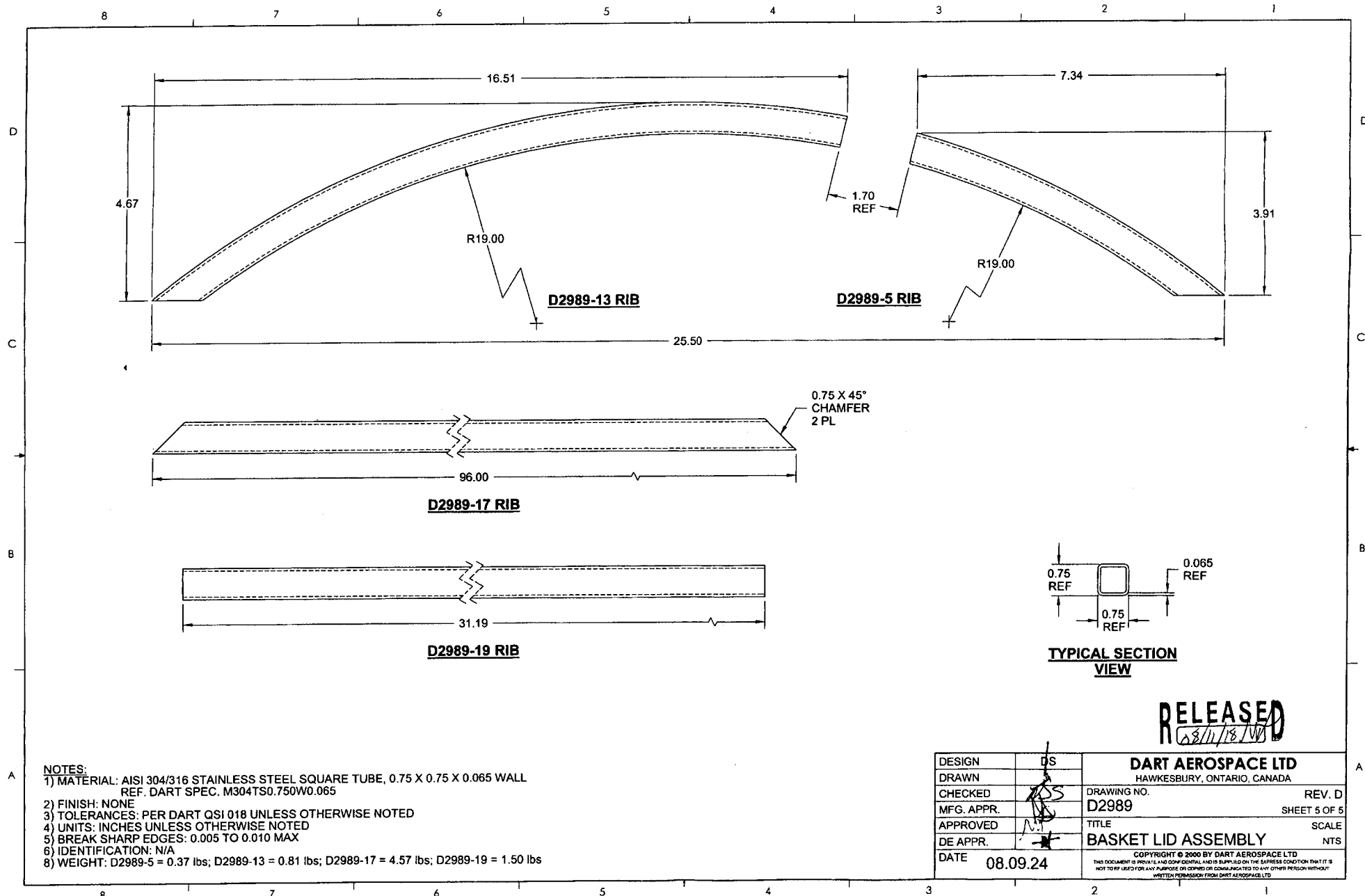
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NOTE: Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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